

Work Order ID 68944 -2
Tuesday, April 26, 2011 10:41:03 AM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 4/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/2/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date: 4/26/2011

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100



FLOW WATERJET

0.00

Waterjet

Memo

0.00

10-5-2

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev C Prog Rev C 2-Debur
if necessary

(149)

304.063

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-5-2

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

counter
x49

Quality Control

8 uloslor

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Page 2

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Required Date: 5/2/2011 Req'd Qty: 40.00

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Setup Start



Stop



Cust Item ID:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Item as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

0.00

0.00

(49)

SB 1105103

140



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
1117659 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

0.00

0.00

EL 11-5-31 (42)

150



QC

Quality Control

QC10- Inspect visual per OSI004- ground welds

Memo

0.00

0.00

8 1105131

(42)

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Cust Item ID:

Required Date: 5/2/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 worst 31

count
42

170

Grey Sandtext (Ref 4.3.5.6) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M115128

START TIME

FINISH TIME

OVEN TEMPERATURE

320°F

1:40

2:10

42 x 6 M-L 11/05/31

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

42 x 6 BR 11-5-31

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Page 4

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Cust Item ID:

Required Date: 5/2/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

190



Packaging

Identify as per dwg & Stock Location

F-P 17

0.00

Memo

0.00

Packaging

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

42x / M-L 11/05/31

11/6/07
MK

11-06-02

Picklist Print

Tuesday, April 26, 2011 10:41:10 AM

Page 1

Work Order ID: 68944

Parent Item: D3537-1

Parent Item Name: Wearpad



Start Date: 4/26/2011

Required Date: 5/2/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M364S16GA		Purchased	No			100	sf	175.5000	0.106	4.463158	5.5		



304/316 Sheet.063



1311-5-2

Location

Loc Qty

Loc Code

MAT020

175.5

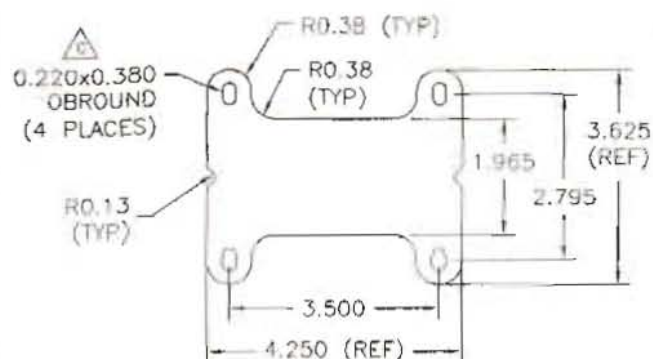
117275

175.5

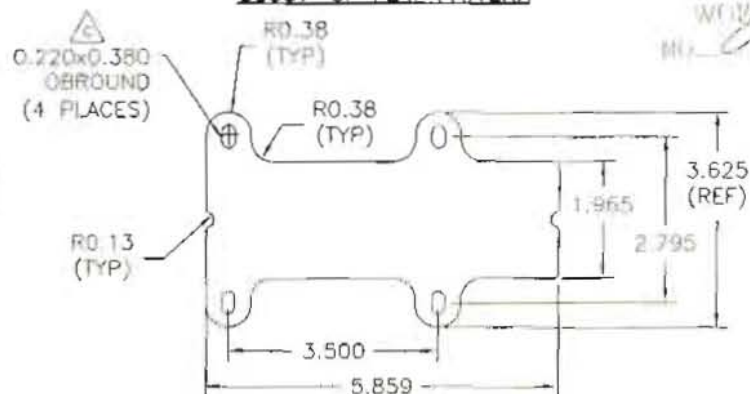
117275

(49)

D3537-1F FLAT PATTERN



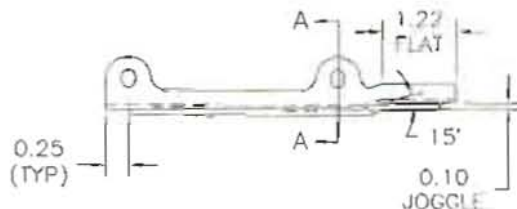
D3537-3F FLAT PATTERN



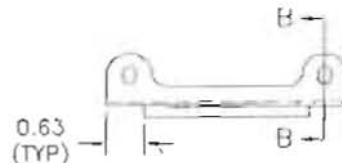
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

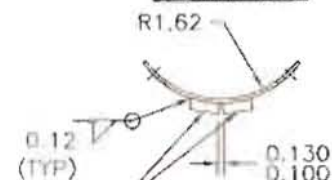


SECTION A-A



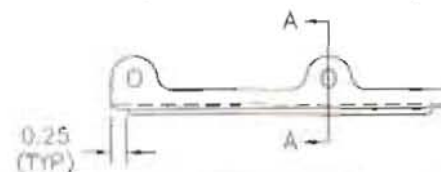
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
		DRAWING NO. D3537
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

RELEASED
07-05-08
DIT ECU
952